

Date: Friday, 16/05/2008 8:45:48 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING		
Job Number	: 39320		Part Number	: D31981		
Estimate Number	: 10416		Drawing Number	: D3198 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 16/05/2008 S.O. No. :		Drawing Revision	: A		
Prsh Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 06/06/2008 Qty: 20 Um: Each		
Previous Run	: 35282					
Written By	:					
Checked & Approved By	: JUO 08.5.16					
Comment	: Est: A - 03.11.11 New Issue KJ/RF Est Rev:B Now on Waterjet 07-01-09 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S11GA	304/316 .125 Sheet 3.5
		Comment: Qty.: 0.1103 sf(s)/Unit Total : 2.2050 sf(s) 304/316 .125 Sheet Batch: 104934 RB 8-5-21
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3198 Dwg Rev: A Prog Rev: A RB 8-5-21
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE RB 8-5-21
		 S08/05/26 X27
4.0	QC8	SECOND CHECK S08/05/26 X27
		 S08/05/26 X27
5.0	BRAKE NC	NC BRAKE Comment: NC BRAKE
		 08/05/26 27 Hm S0 08/05 28 27
		1-Deburr if necessary 2-Form as per Dwg D3198

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 8:45:48 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 39320

Part Number: D31981

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



coated

8/05/28 (27)

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



m/05642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:00

OVEN TEMPERATURE: 320°

FINISH TIME: 10:30

Fx 08/05/29

(27)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PL 08-05-29 (27)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/03 (27)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



10/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

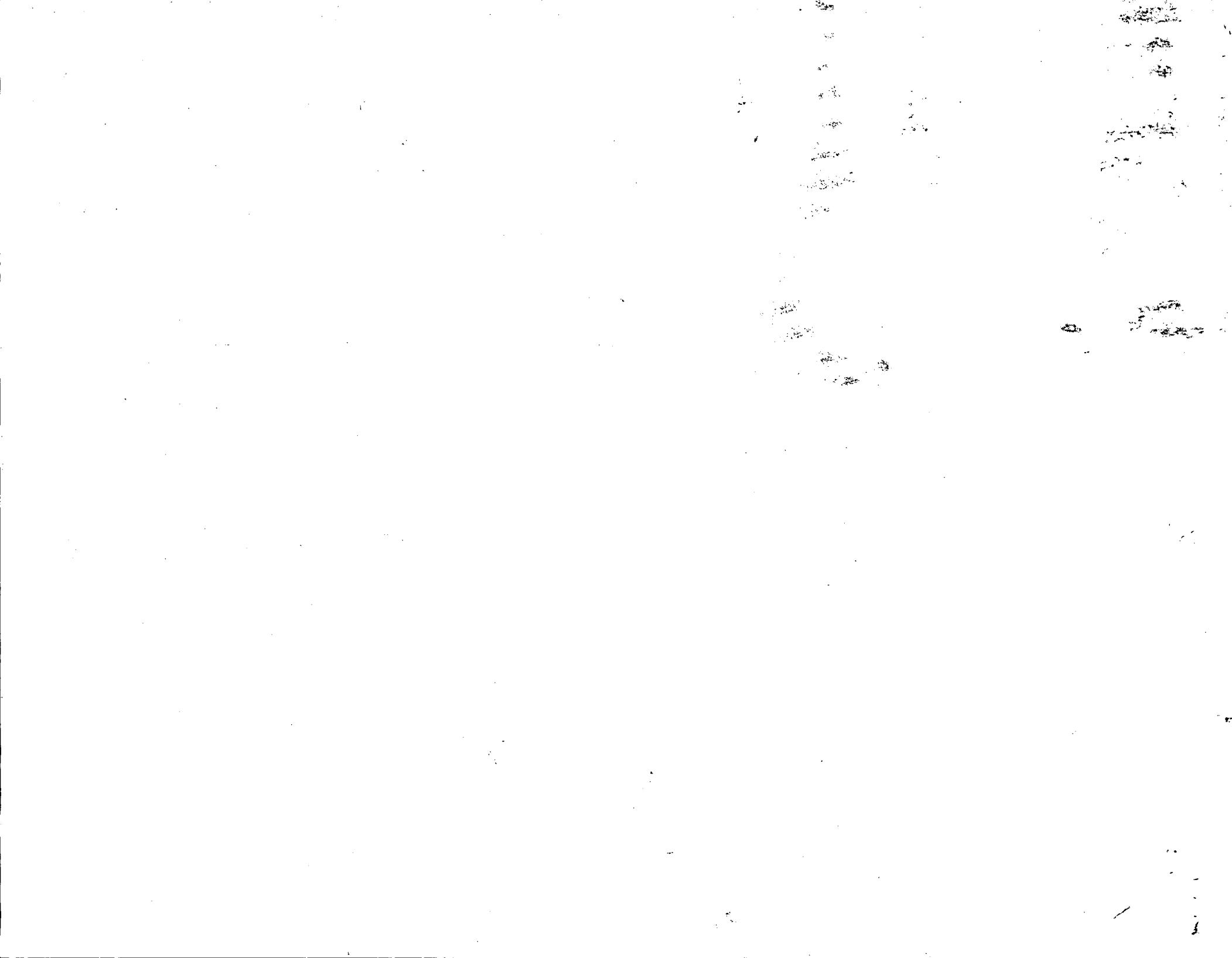
DART AEROSPACE LTD	Work Order:	39320
Description: Fitting	Part Number:	D3198-1
Inspection Dwg: D3198	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

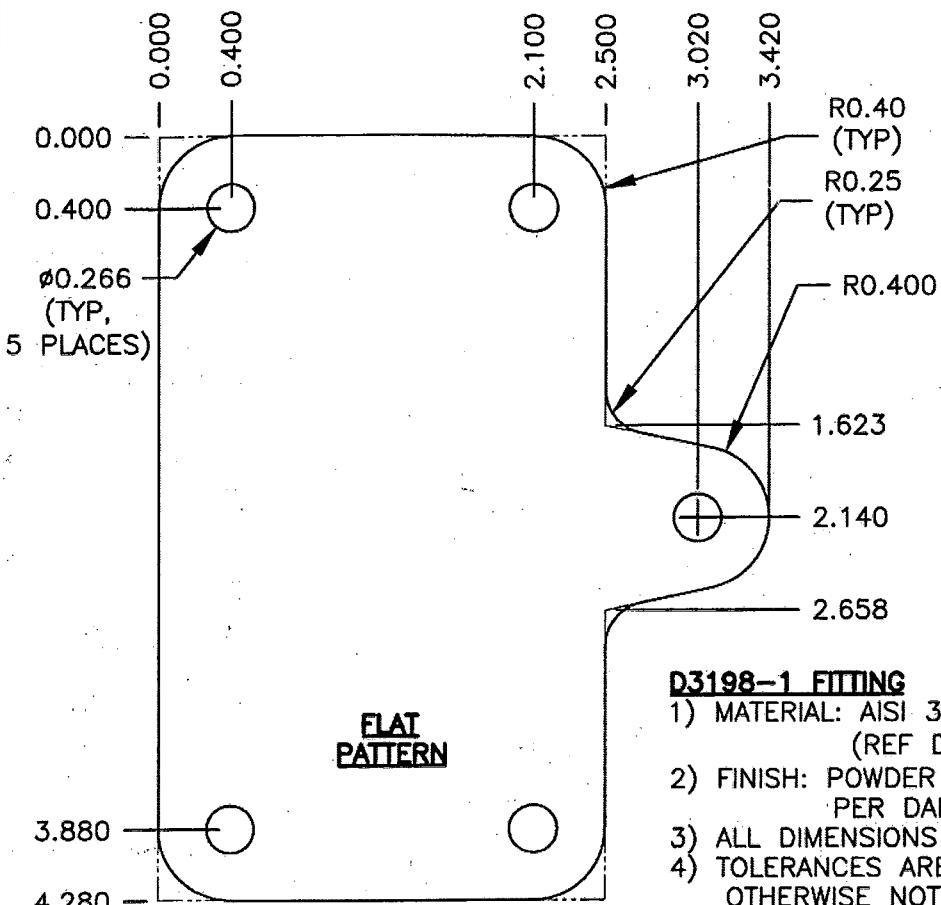
Measured by:	<u>B</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	8-5-21	Date:	<u>08/05/21</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.13	New Issue	KJ/JLM	SJL





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3198	REV. A	SHEET 1 OF 1
DATE 03.09.26	TITLE FITTING		SCALE 1:1	
A	03.09.26	NEW ISSUE		

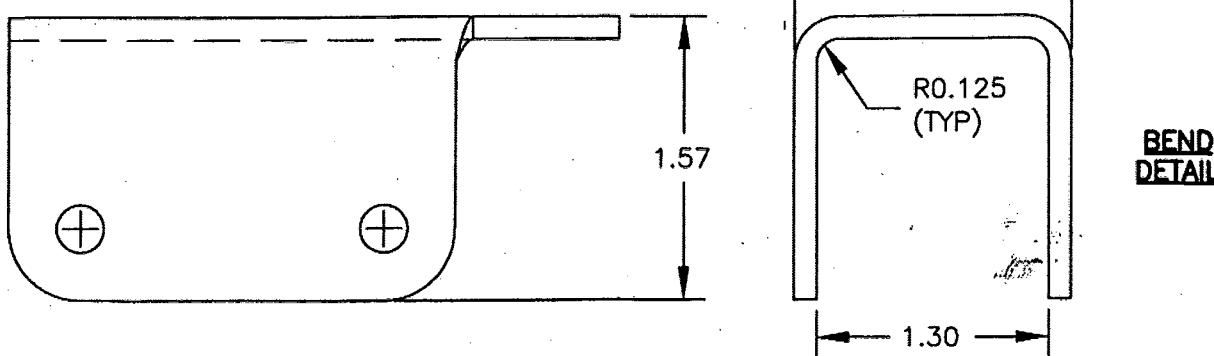


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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87320

D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6)
PER DART QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED
03.10.10 *[Signature]*



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